

Work Order ID 72461

Monday, July 25, 2011 3:59:13 PM



Page 1

Item ID: D2580-1

Accept



Setup Start



Revision ID:

Item Name: 205 Skidtube bent detail

Stop



Start Date: 7/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-07-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

RevD DEO-D1

100

0.00



Skidtubes

Skidtubes

Memo

0.00

1- Inspect mat'l D2500-1-190 for damage.

2-Drill pilot holes using drill jig DT 8149 (Do not use cutting fluid)

3-Open holes to 0.500" as per Dwg D2580 without cutting fluid

4-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube

5- Chemical Conversion Coat as per QSI 005 4.1

6-Bond web in place per QSI 015.

□□

A/R Sikaflex-291 batch: 117514 □□□

Sikaflex expire date: 12/01/15.

Start time and date: 5:00 PM bond for 12hrs

Wh 11/08/02

Wh 11/08/02

Wh 11/08/02

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Page 2

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Required Date: 8/5/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
101 	QC6- Inspect dimensions to drawing	0.00							
QC Quality Control	Memo	0.00				2	0	BEU/08/03	
130 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				2	0	BEU/08/03	
140 	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
Packaging Packaging	Memo	0.00				2	0	BEU/08/03	

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Page 3

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Stop



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Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/04

11-08-11
(2)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, July 25, 2011 3:59:19 PM

Page 1

Work Order ID: 72461

Parent Item: D2580-1

Parent Item Name: 205 Skidtube bent detail

Start Date: 7/25/2011

Required Date: 8/5/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP B01.11.08 Revised Step 9, 10, 12, and 13 SM IPP Rev:C
10.12.01 as per DEO D1 DD verf:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2500-1-190

Manufactured No

100

Each

45.0000

1

2



Ext'n - I' Beam Tube 4"

Location

Loc Qty

Loc Code

HALL

3

58427

3

LG

42

66296

42

D2596

Manufactured No

100

Each

4.0000

1

2



Web, 205 Skidtube

Location

Loc Qty

Loc Code

LG046

4

72263

4

2

DL

11/08/02

DL

11/08/02

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DART**RELEASED**
07.06.28 #D**DEO ATTACHED**
UNDER REVIEWPhoto
RMV 07.06.28

DESIGN <i>[initials]</i>	DRAWN BY <i>[initials]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72-964

11-07-25

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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DART		DART AEROSPACE LTD. HAMMERSBURY, ONTARIO, CANADA	
DRAWING NO. D2580		REV. D SHEET 2 OF 3	
TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:24	

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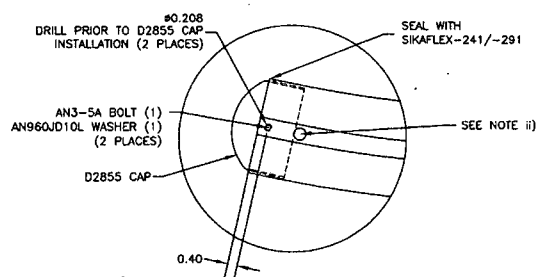
Diagram of a circular cross-section of a pipe with four internal stiffeners. The stiffeners are spaced 3.500 inches apart, and the distance from the outer edge of the pipe to the center of each stiffener is 1.750 inches.

RELEASED
07-06-78

~~DEO ATTACHED~~

RMV 6P4.06.34

DETAIL G
SCALE 5:24



D2579 SPACER

D2596 WEB (REF)

ALS7-1032-130 (REF)
(TYP 50 PLACES)

AFTER PERFORM
1. CHA
2. INS
3. WE
4. C'B

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

[illegible]

5.985
5.338 (REF)
51.340
39.580
5.915
3.630 (REF)
Ø0.508 (8 PLACES)
Ø0.640
20.0
1.4
1.0
13.4
DISTANCE BETWEEN HOLE AND TANGENT POINT
1.0
DISTANCE BETWEEN HOLE AND TANGENT POINT
32.0 ± 1.0

HULL BOTTOM ASSEMBLY DETAIL

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

NO C'BORE NO PLUG

NO C'BORE NO PLUG

NO C'BORE NO PLUG

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-1

AN3C4A BOLT (1)

AN960C10L WASHER (1)

(50 PLACES)

DESIGN	DRAWN BY	I

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DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED <i>HA</i>	APPROVED <i>HA</i>		
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	
		SCALE 1:2	

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